

20

DART AEROSPACE LTD	Work Order:	20700
Description: Hinge Bracket	Part Number:	D2857-1
Drawing: D2857 Rev. A1	Qty:	24

RF 03-09-05

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	KJ	04.04.13	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)		Batch M117CX 3nB 04/04/13	24
3	HAAS	Machine per folio D2857-1	SP	04/04/13	24
4	QC	Inspect Level 2	SP	04/04/13	24
5	METAL	Tumble Deburr any rough edges after tumbling	SP	04/04/13	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	MM	04.05.05	24
7	QC	Inspect Level 7	SP	04.05.05	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	MM	04.05.06	24
9	QC	Inspect Level 3	SP	04.05.06	24
10	STORES	Identify and stock	MM	04/05/06	24
11	EXPEDITING	Close W/O Cost / Part: 19.85 \$45 04/05/10 (24) 20.23	KJ	04.05.11	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

EC JUN 2 6 2009

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

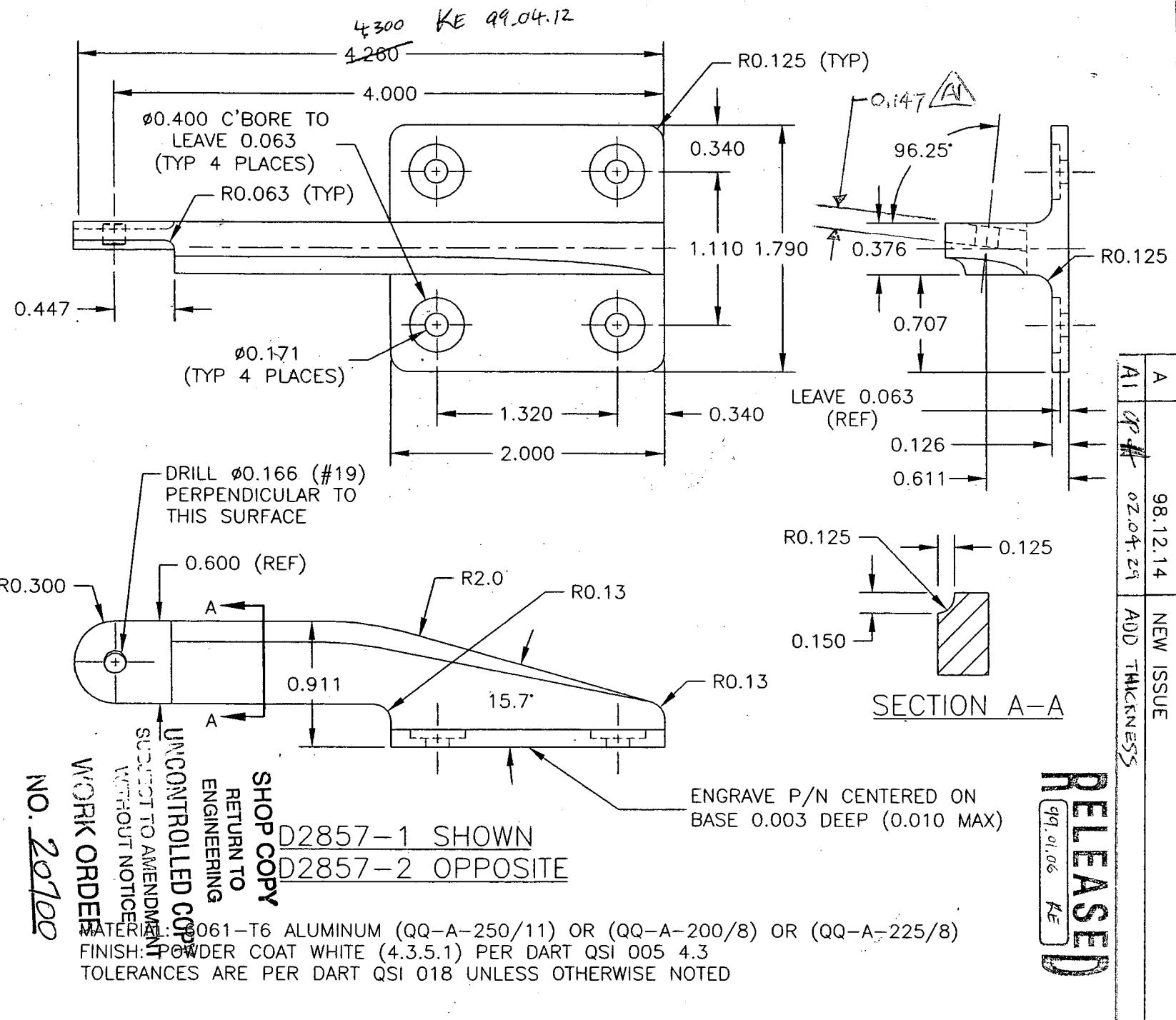
NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
07/12/03			Initial						

PAR#: _____

Fault Category: _____

DQA: _____

Date: _____



DART

**QACOPY IS
GIVEN**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	JP	HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	JP	D2857	SCALE
DATE	98.12.14	TITLE	1:1
A	98.12.14	NEW ISSUE	
A1	98.04.29	ADD THICKNESS	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2004
03:42 pm

Work Order No	:	0020700	Department Code:
Project Name	:	D2857-1	Burden Flags : NNNNNNN
Project For	:	WK420	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2857-1	Invoice Number :
Description	:	Hinge Bracket	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	24	
Amount Done	:	0	Order Entry No :
Start Date	:	04-12-04	OE Value : 0.00
Est Finish Date	:	05-12-04	
Act Finish Date	:		Est Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DARC AEROSPACE LTD

Work Order:

20700

Description:

Hinge bracket

Part Number:

D857-1

Inspection Dwg:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	$\pm .010$	4.308	✓			
.340	"	.339	✓			
.718	$\pm .005$	1.111	✓			
1.790	$\pm .010$	1.93	✓			
1.320	$\pm .005$	1.319	✓			
2.000	$\pm .010$	2.003	✓			
<u>.171</u>	<u>$\pm .003$</u>	<u>.171</u>	<u>✓</u>			
<u>.147</u>	<u>$\pm .010$</u>	<u>.146</u>	<u>✓</u>			
<u>.376</u>	<u>"</u>	<u>.375</u>	<u>✓</u>			
<u>.126</u>	<u>"</u>	<u>.125</u>	<u>✓</u>			
<u>.063</u>	<u>"</u>	<u>.063</u>	<u>✓</u>			
<u>.166</u>	<u>$\pm .003$</u>	<u>.167</u>	<u>✓</u>			
<u>.911</u>	<u>$\pm .010$</u>	<u>.909</u>	<u>✓</u>			
<u>.600</u>	<u>"</u>	<u>.599</u>	<u>✓</u>			
<u>.125</u>	<u>$\pm .010$</u>	<u>.132</u>	<u>✓</u>			
<u>.150</u>	<u>"</u>	<u>.154</u>	<u>✓</u>			

Measured by:		Audited by:		Prototype Approval:	
Date:	07/07/07	Date:	07/07/07	Date:	N/A

Rev:	Date:	Change:	Revised by:	Approved:
A		New Issue	KJ/RF	